



Dart Aerospace Ltd.
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646.9601
Job Sheet 204972



Part No: 646.9601 Job Qty: 4 pcs
Part Name: Upper Cutter Assembly

Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 12/23/19 Job Tracking No:
Due Date: 2/14/20 Created By: Marie Lajeunesse
Type: ~~Stock~~ **SOLD** Description:
Note: DWG REV N/C IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs		2/14/20	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		DAS
							Packaging 1 - 22		41 JAN 08 2020
							Packaging 1 - 23		9-89
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		



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Container No: S245698



Part: 646.9601
Job No: 204972
Serial No/Batch: S245698

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 01/08/20

120 Small Fab - 2 - B4B	4 pcs	2/14/20	0.00 1.86	Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				Packaging 1 - 37	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	DAS
				Small Fab - 6 - B4B	41 JAN 08 2020
				Small Fab - 7 - B4B	9-89
				Small Fab - 8 - B4B	
130 QC 5	4 pcs	2/14/20	0.00 0.00	Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS JAN 09 2020 40
				QC 5 - 61	9-89
140 Packaging 3-1 - Stock - B4B	4 pcs	2/14/20	0.00 0.00	QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	DAS CCK039 80
				Packaging 3 - 4 - B4B	9-89
				Packaging 3 - 5 - B4B	JAN 10 2020
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	

				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
150 QC 21 - SA	4 pcs	2/14/20	0.00 0.00	QC 21 - SA - 21 ✓	CCF 039
				QC 21 - SA - 70	0.5
				QC 21 - SA - 53	JAN 10 2020

Part Op 110 - (Pick Kit)
Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2. A/R RTV LOCTITE
598: 5142190 exp 10/20
130 - (QC5- Inspect part completeness to step on W/O)
140 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER IAW MPP-120***
150 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
646.9701	Cutter Sub Assembly	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5244661(2) 5234843(2)
646.9811	Upper Deflector	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5022577
MS21042L08	Nut	12 Ea (3 ea)	110-Packaging 1 - Pick Kit	5231236
MS27039-08-19	Screw	12 Ea (3 ea)	110-Packaging 1 - Pick Kit	5231293
NAS1149FN832P	Washer (AN960-8)	24 Ea (6 ea)	110-Packaging 1 - Pick Kit	5235228

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.9701	4	3	0
	646.9811	4	6	0
	MS21042L08	12	794	0
	MS27039-08-19	12	842	0
	NAS1149FN832P	24	1,652	0

Part Specifications	
Specifications could not be found.	



Job: _____		DISPOSITION		DEPARTMENT/PROCESS																																							
Part No. _____		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality																																	
Date :		Sequence #:		QTY Affected :		MRB (QS1042)																																					
Description Work Order Deviation				Disposition																																							
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY <table><tr><td> Pressure/Forced </td><td> Contamination </td><td> Power Loss/Surge </td><td> Positioned Wrong </td></tr><tr><td> Bending </td><td> Misaligned/off center </td><td> Folio/Program </td><td> Outside Tolerance </td></tr><tr><td> Crushing </td><td> BOM/Route </td><td> Grain Direction </td><td> Drawing </td></tr><tr><td> Cracks </td><td> Broken/Damage/Defect </td><td> Weld </td><td> Finish </td></tr><tr><td> Crimp/Kink/Ripple/Wave/Twist </td><td> Incomplete/Unclear Instructions </td><td> Wrong Stock Pulled </td><td> Part Lost/Missing </td></tr><tr><td> Marks/Chatter </td><td> Drill Holes </td><td> Out of Sequence </td><td> Misread </td></tr><tr><td> Mislabeled </td><td> Fit/Function </td><td> Off-set/Set-up </td><td></td></tr><tr><td colspan="4">Other/Details:</td></tr></table>								Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up		Other/Details:			
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Other/Details:																																											
Completed By																																											
Lead hand / Supervisor																																											
QC / QA Coordinator																																											